

Date: Tuesday, 8/7/2007 5:34:24 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 33839		
Estimate Number	: 10872		
P.O. Number	: N/A	Part Number	: D32452
This Issue	: 8/7/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3245 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A
	Type : PURCHASED PARTS	Material	: N/A
Written By	: <u>Jul 07-08-07</u>	Due Date	: 8/14/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est. A 04.07.07 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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X Comment: Qty.: 0.8442 sf(s)/Unit Total : 0.8442 sf(s)

304/316 .032 Sheet

Batch: M105061

SAD 07/08/07

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3245 ****prog.D3245-1/-2****

(No Holes) Jul

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SAD 07/08/07

①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/07

①

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Jul 07-08-08

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary

C'sink as per Dwg D3245

Form D3245-1 as per Dwg D3245 Identify as D3245-1

mf

07-08-09

SAD 07/08/08

②

Date: Tuesday, 8/7/2007 5:34:25 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU2DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 33839

Part Number: D32452

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/09 (1)-042

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST*

JL 07-08-10

(1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-10

(1)

Job Completion

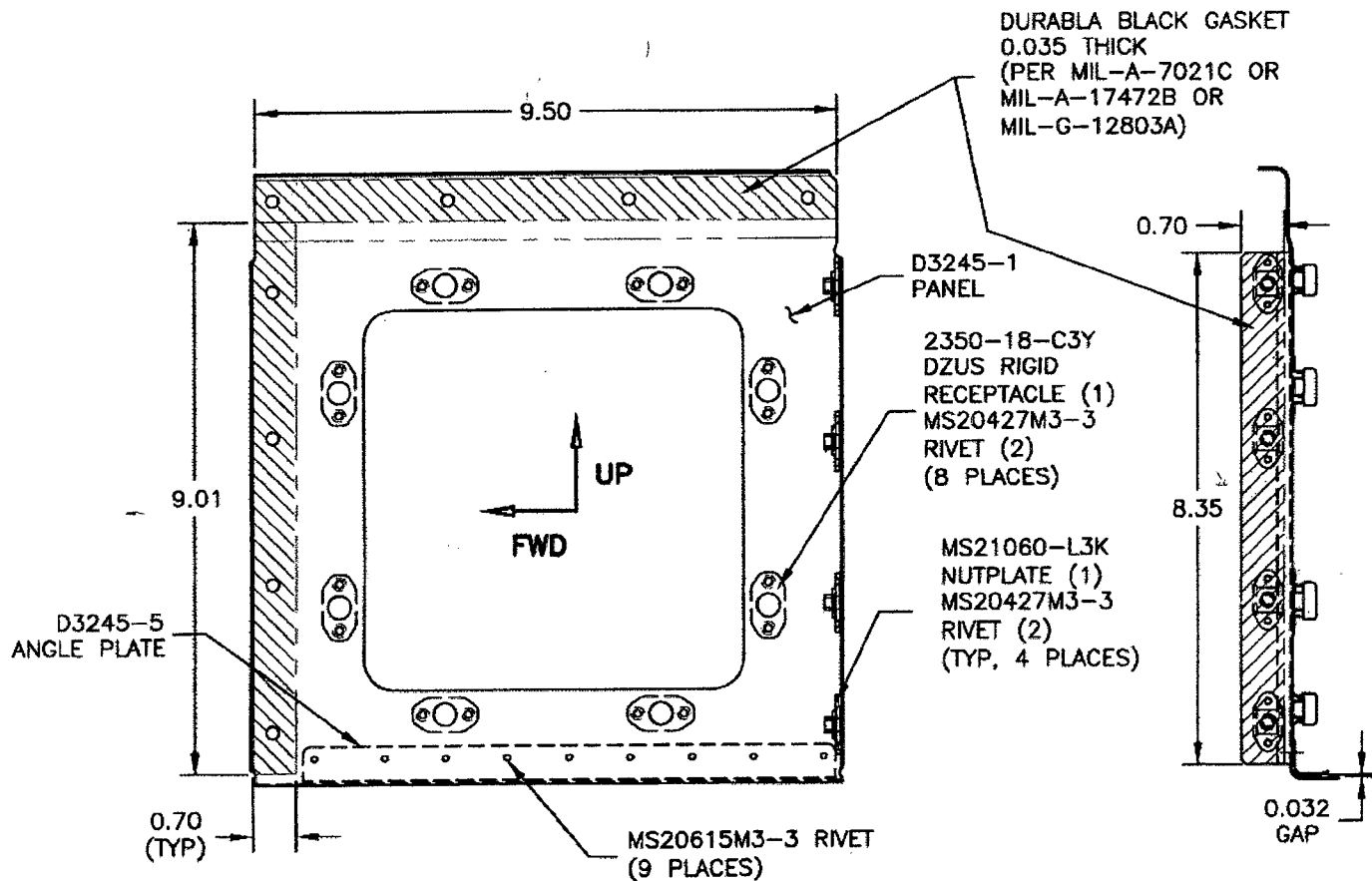


JL 07-08-10



DESIGN	RF	DRAWN BY	P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3245
DATE	04.01.27	TITLE	ACCESS PANEL ASSEMBLY	REV. A SHEET 1 OF 6
A	04.01.27	NEW ISSUE		SCALE 1:3

RELEASED
04.04.21



D3245-041 ACCESS PANEL ASSEMBLY

D3245-041 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

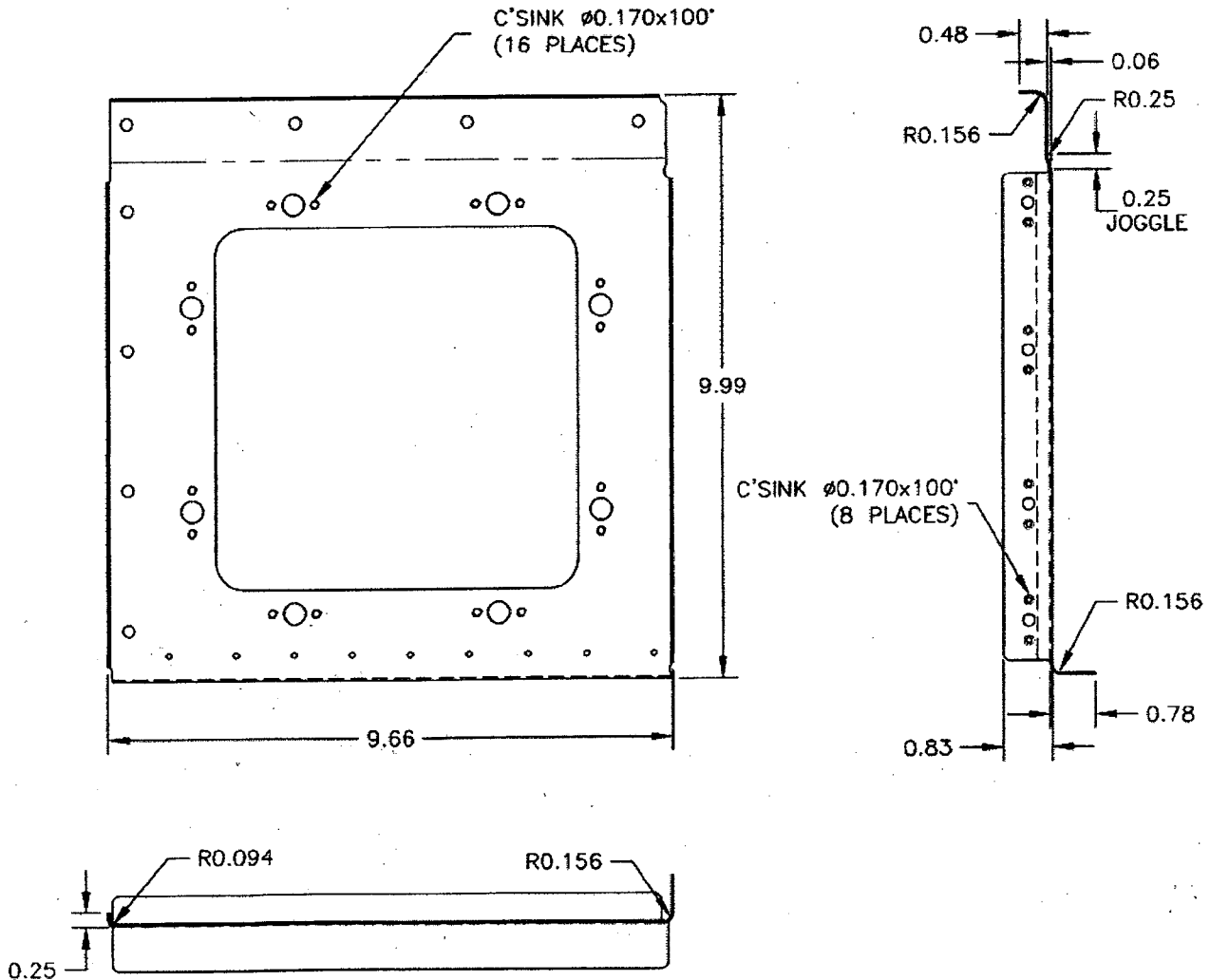
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DESIGN RF	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3245	REV. A SHEET 3 OF 6
DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:3

RELEASED
04.04.21



**D3245-1 PANEL BEND DETAIL SHOWN
BEND D3245-2 PANEL OPPOSITE**

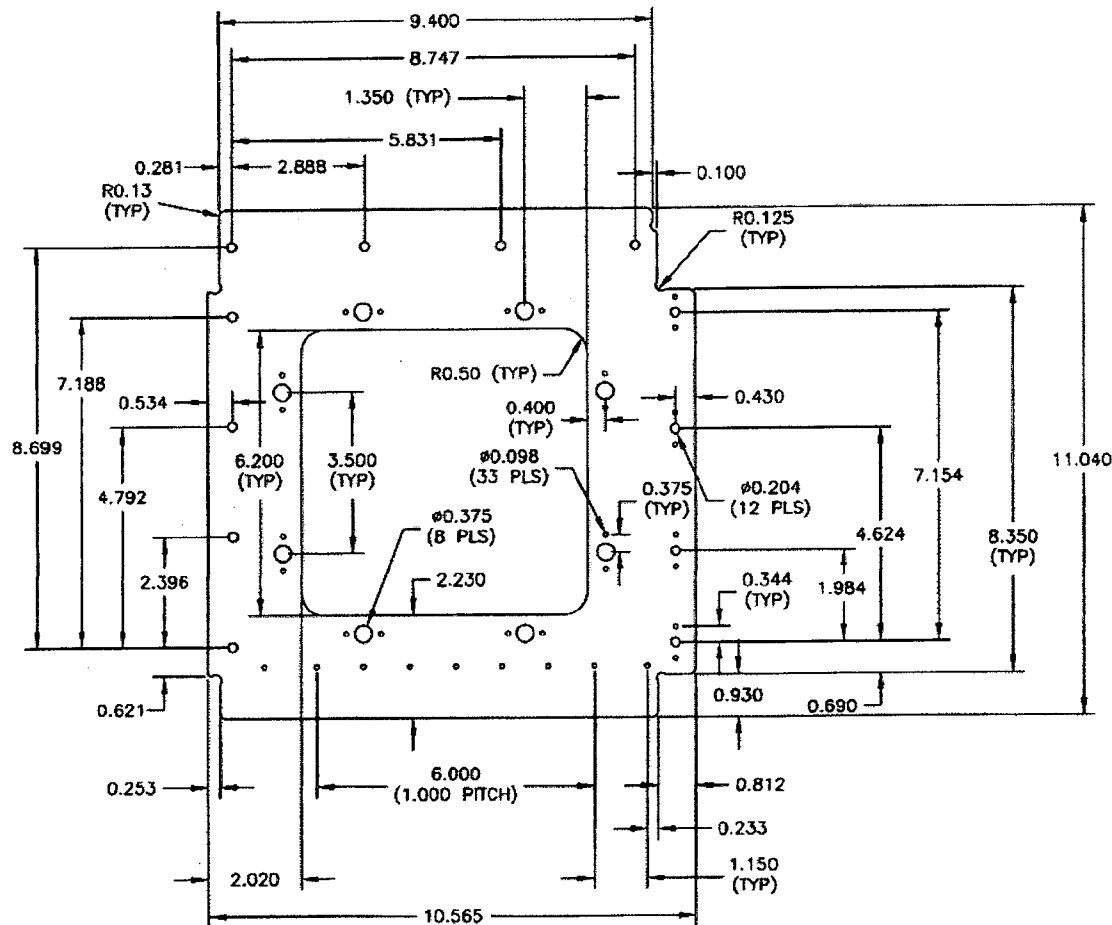
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DESIGN	RF	DRAWN BY	Q	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3245	SHEET 4 OF 6
DATE	04.01.27	TITLE	ACCESS PANEL ASSEMBLY	SCALE	1:4

RELEASED
04.04.21 #



D3245-1/-2 PANEL FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order:	33838
Description: Pane		Part Number:	D32451
Inspection Dwg: D3245 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article

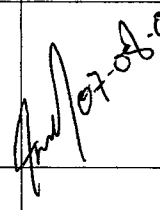
Prototype

[illegible]

Measured by:	SAA	Audited by:	[Signature]	Prototype Approval:	
Date:	07/08/08	Date:	07-08-08	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/09	6-1	8 2350-18C3X 16 MS 20427H 3-3 9 MS 20215H 3-3	Batch <u>M19688</u> ✓ Batch <u>M101840</u> ✓ Batch <u>M17654</u> ✓	mf	07-08-09	1		
		1 D 3245-5 Durable black Gasket 1 .700 X 8.35 1 .700 X 9.50 1 .700 X 9.01	Batch <u>B33837</u> Batch <u>B23711</u>					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries